

Date: Friday, 5/25/2007 8:36:41 AM  
 User: Kim Johnston

Process Sheet *SPUT*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM	POSITIVE RECALL
Job Number : 32645 -4		EFFECTIVE 07.06.05 AUTH <i>JP</i>
Estimate Number : 12882		RELEASED 07.06.06 DATE <i>JP</i>
P.O. Number : N/A	Part Number : D3560042	
This Issue : 5/25/2007 S.O. No. : N/A	Drawing Number : D3560 REV.B	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A	Drawing Revision : B	
Previous Run : N/A	Material : N/A	
Written By : <i>JP 07.05.25</i>	Due Date : 6/5/2007	Qty: 30 Um: Each
Checked & Approved By : <i>JP 07.05.25</i>		
Comment : Est Rev: A New Issue 07.05.24 EC		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s).  
 6061-T6 Bar 0.50" x 5.00" *M 104598 X 20 pcs*  
 Batch: *17625X10* *J.F./BG 07.06.01*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks 16.750" long

*J.F./BG**07.06.01*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA694 Rev: *AA* & Dwg D3560 Rev: *B*2-C'sink 0.196" hole on manual mill as per dwg D3560 *SAO 07/06/28*

3-Deburr per dwg D3560

*J.F./BG**07.06.01*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F./BG**BG 07.06.01*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*D.F. 07/06/12**SPUT* *(19)*





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.06	11	NO POWDER COAT. CHEM. CONV. COAT ONLY. REF ATTACHED DS EMAIL				CP 07.06.06 P.W. QSI 042	J 07.06.07	
07.06.28	12	D2808 Bore <u>18.28600 / 18.32752</u> Put Bush	PE	07.06.27	6	U 07.06.16		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07.06.04  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.06.08	3	Qty(1) C-Bore $\phi 0.510$ INSTEAD OF $\phi 0.507$	CP 07.06.08 P.W. QSI 042	SCRAP/REPLACE	J.F. 07/06/27	07.06.27	CP 07.06.08 P.W. QSI 042	J 07.06.27
07.08.22	8-0	6 parts have cracks in the $\phi 3592-1$ plate, due to too much heat transfer to give deeper weld penetration. R.C. Too hot of a weld on the plate.	QSI 042	Remove the $\phi 3592-1$ plate from the run, and grind flush, and access weld. <del>Remove the <math>\phi 3592-1</math> plate</del> <del>Weld as</del> * verify by Q.C *	07.08.23 07.10.01	Q.M. PD	QSI 042	J 07.08.22
↓	↓	↓	QSI 042	Remove the $\phi 3592-1$ plate from the run, and grind flush, and access weld. Weld plate as normal, and as per Dwg. Scrap & destroy	PE 07.10.01	CP 07.08.22	QSI 042	J 07.08.22

NOTE: Date &amp; initial all entries





Date: Wednesday, 15/08/2007 7:40:14 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32645

Part Number: D3560042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

see page #1

7.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

~~B 32662~~ B 32661

SE 07-08-15

6

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

SE 07-08-15

6

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Alco/01

~~SE 07-08-15~~

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PTO

PD 07-10-01

see previous page

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3





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Job Number: 32645

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

17.0

EMP COST ADJ

Employee Labour Cost Adjustment



Comment: Sub-Contracting Employee Labour Cost Adjustment

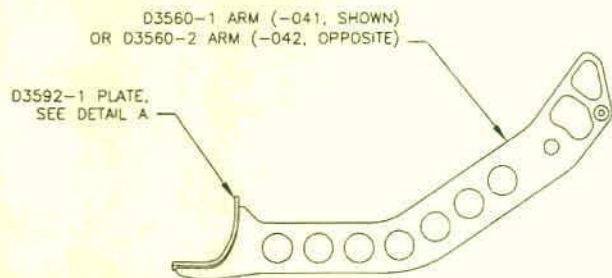
Job Completion



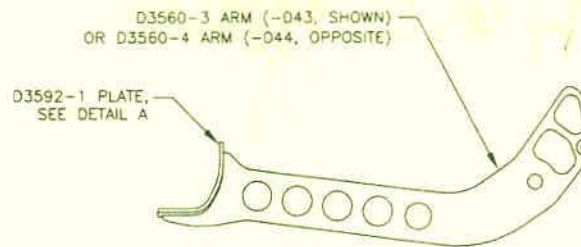
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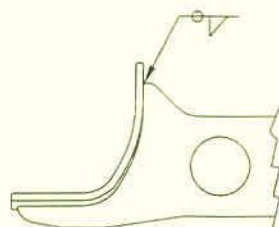
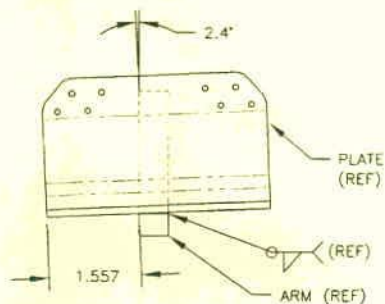


D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)

*n/o 32645*



DETAIL A  
(SCALE 1:1)

**GENERAL NOTES**

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
*07.06.19*

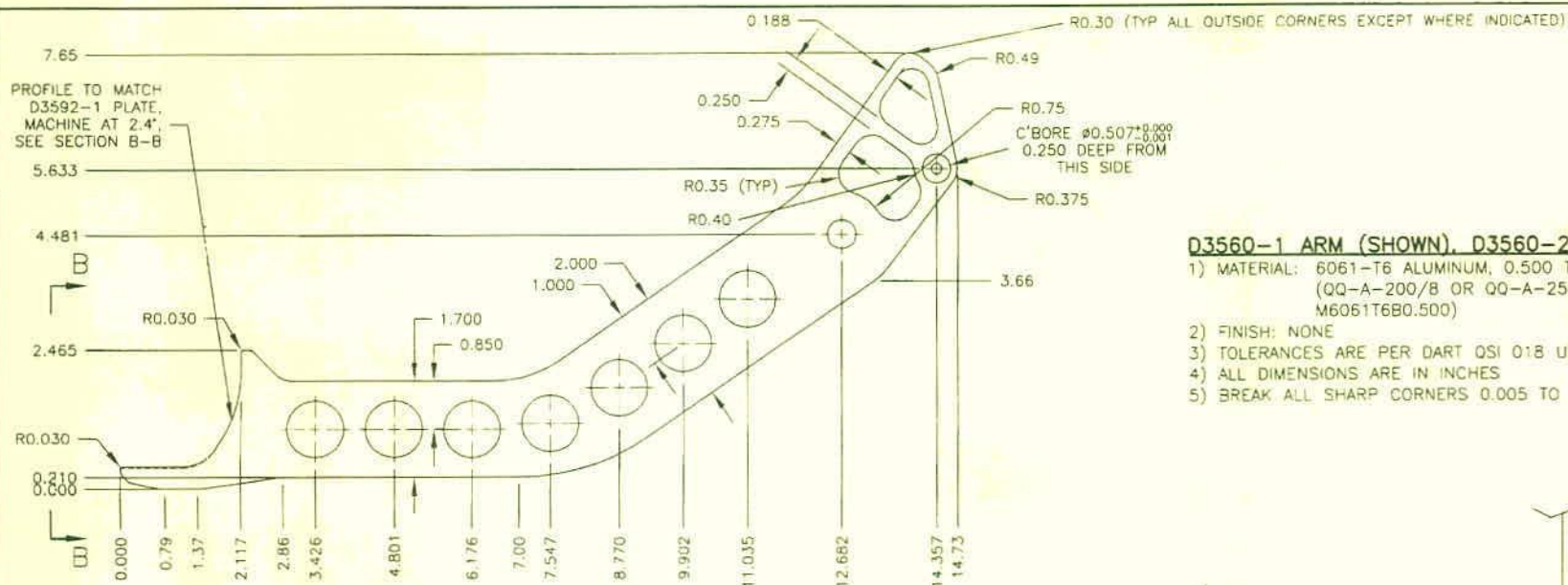
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE	TITLE	SCALE 1:4
07.06.19	ARM WELDMENT	

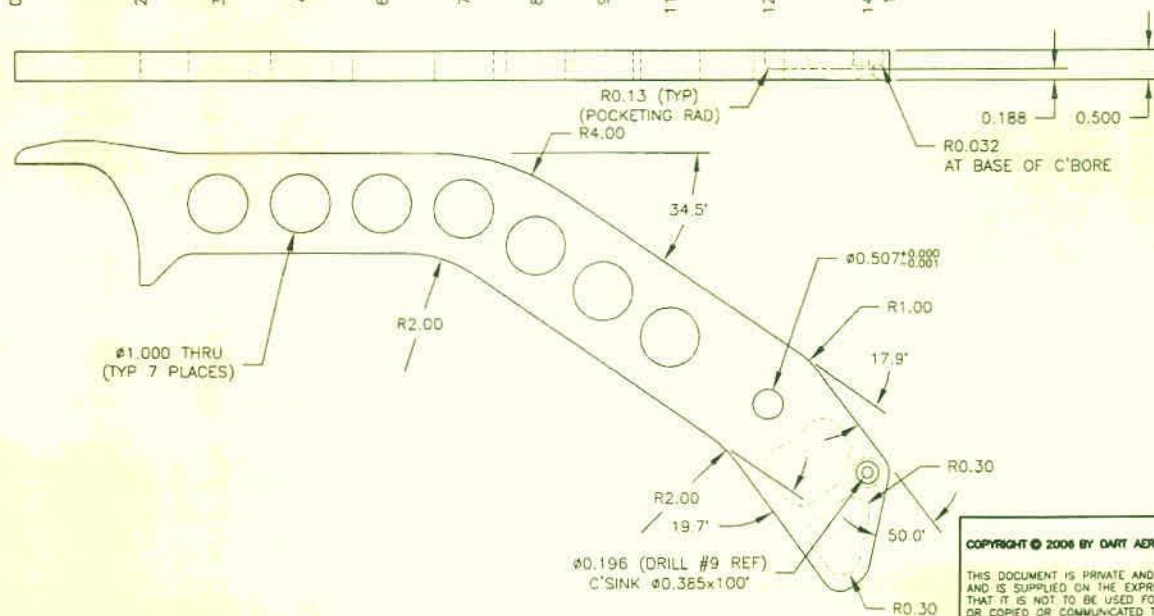




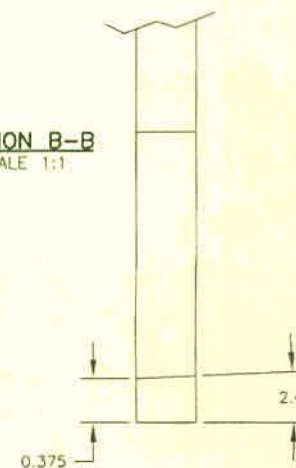


**D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/B OR QQ-A-250/11, REF DART SPEC.  
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION B-B**  
SCALE 1:1



**RELEASED**  
07.06.29

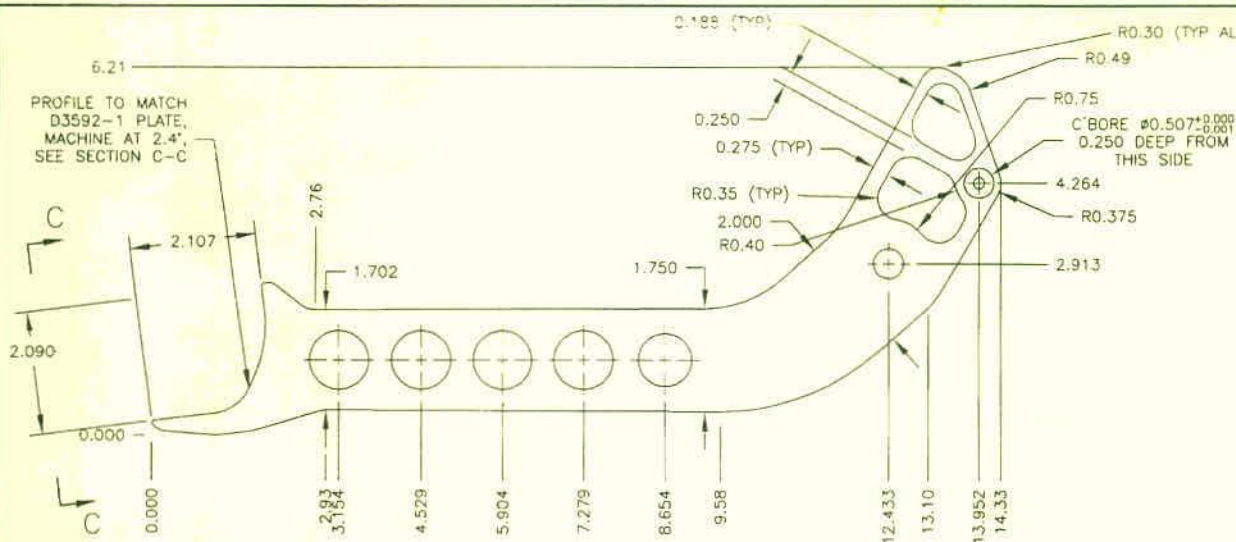
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CHECKED	df	APPROVED	df	DRAWING NO. D3560	REV. C SHEET 2 OF 3
DATE	07.06.19	TITLE	ARM WELDMENT	SCALE	1:2

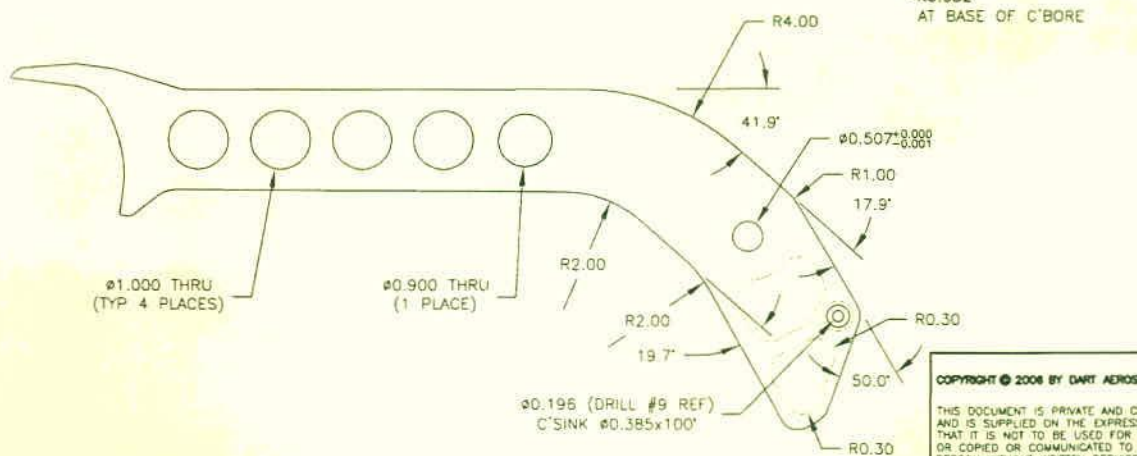
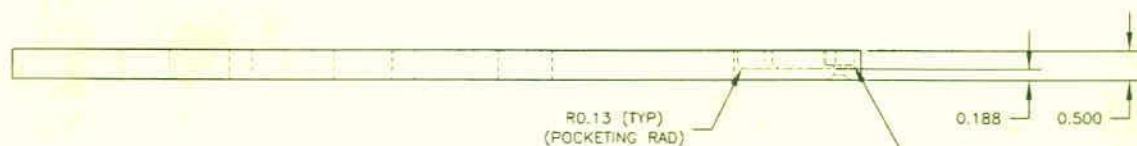




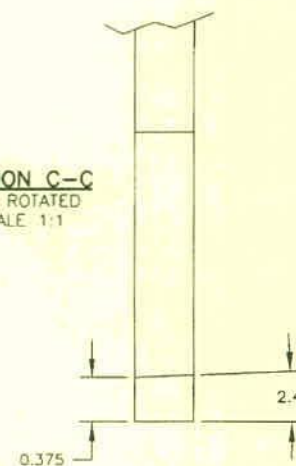


**D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



**SECTION C-C**  
VIEW ROTATED  
SCALE 1:1



**RELEASED**  
07.06.19

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CHECKED	th	APPROVED	th	DRAWING NO. D3560	REV. C SHEET 3 OF 3
DATE	07.06.19	TITLE	ARM WELDMENT	SCALE	1:2

